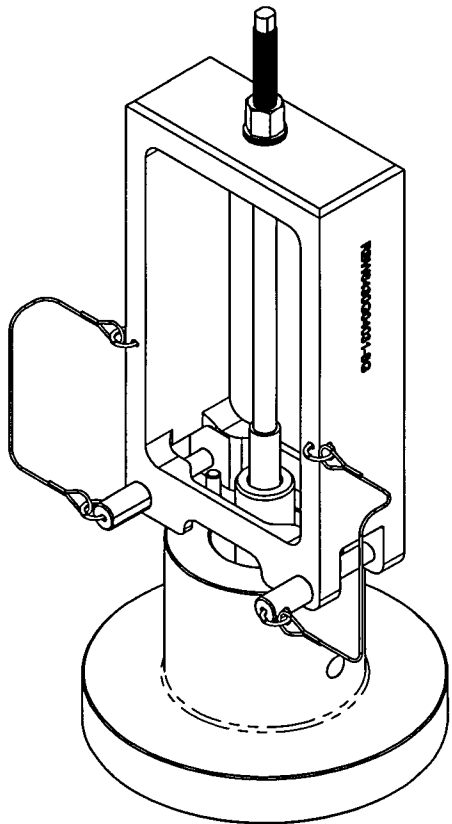


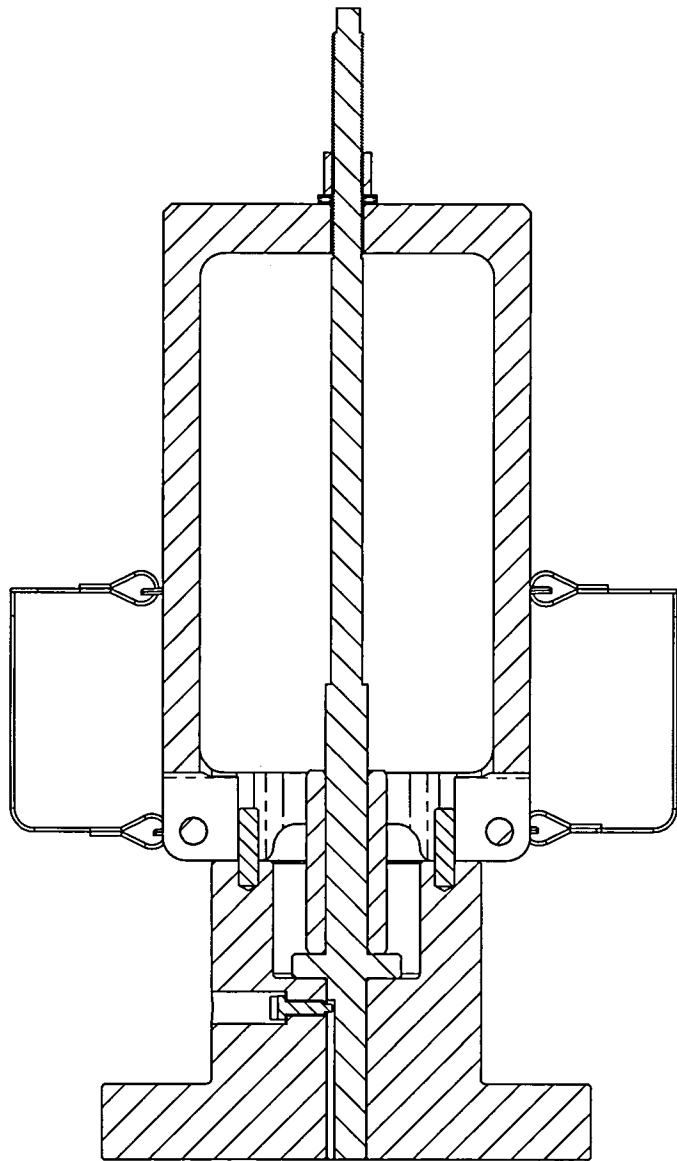
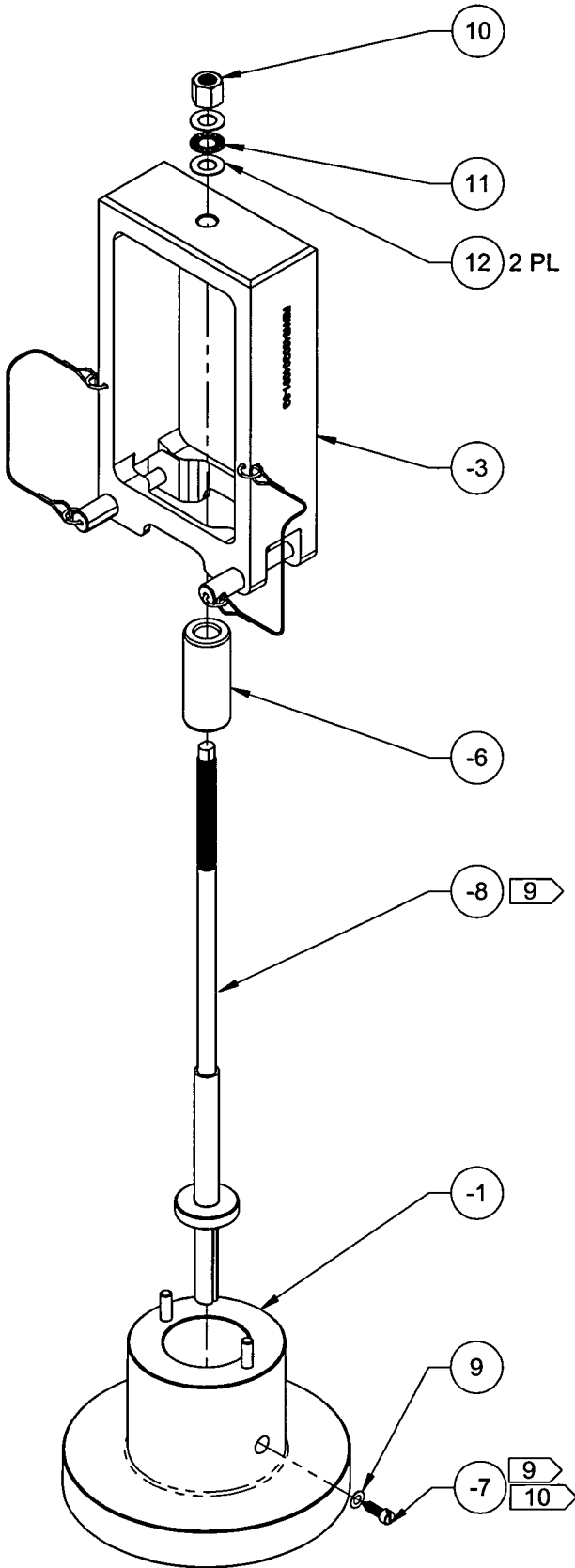
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6430G04031-8G-1	BASE ASSY
-3	1	RBW6430G04031-8G-3	REACTION ASSY
-6	1	RBW6430G04031-8G-6	BUSHING
-7	1	RBW6430G04031-8G-7	SPECIAL SCREW
-8	1	RBW6430G04031-8G-8	PULLER
9	1	McMaster#95229A420 OR EQUIV	STEEL FLAT WASHER FOR 1/4" SCREW SIZE
10	1	McMaster#90565A330 OR EQUIV	STEEL HIGH HEX NUT 1/2"-20 X 11/16" LG. GRADE 8
11	1	NTA-815	NEEDLE ROLLER THRUST BEARING
12	2	TRC-815	THRUST WASHER



RBW6430G04031-8G T/R DUPLEX BEARING INSTALLATION ASSY

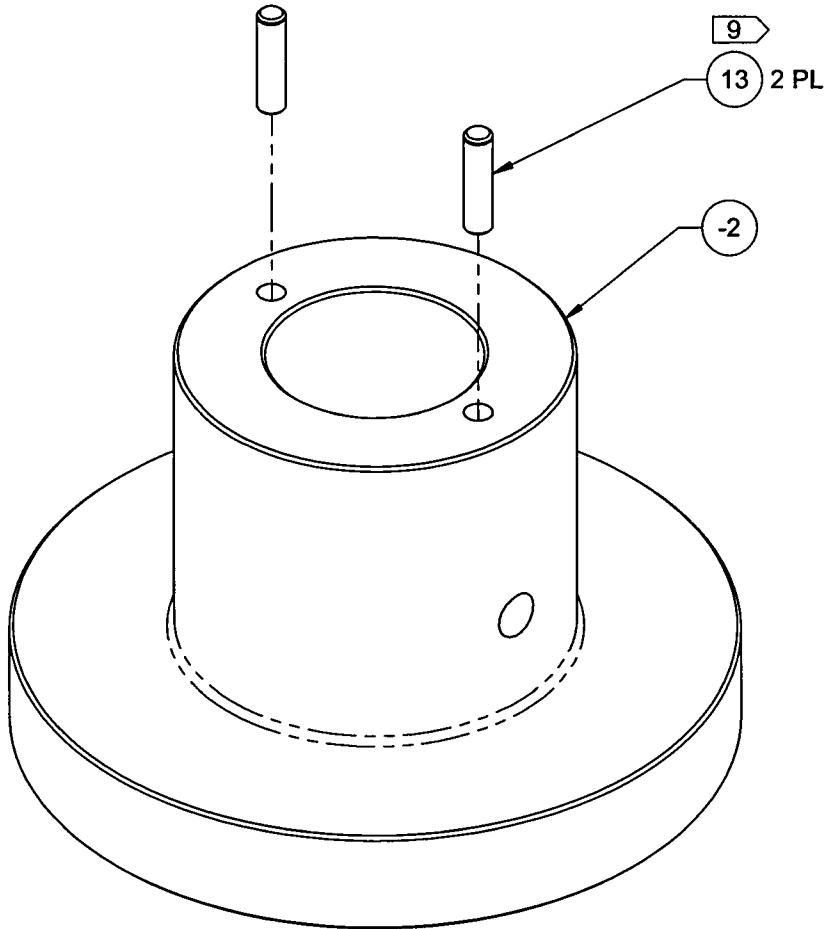
11

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) GROOVED FEATURE ON ITEM -8 MUST ALIGN WITH ITEM -7
 - 10) INSTALL ITEM -7 HAND TIGHT
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

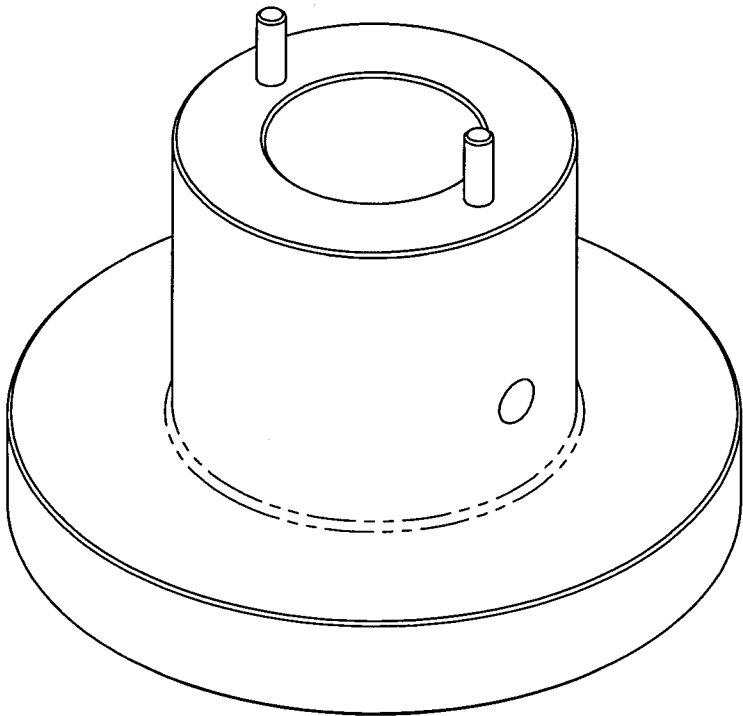
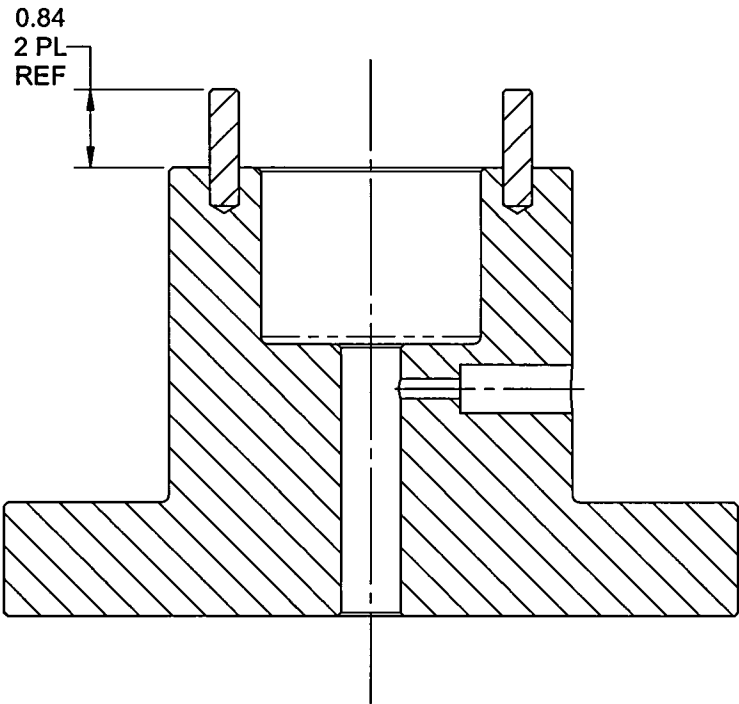


A	NEW ISSUE	18-578	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 1 OF 9
APPROVED	VM	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6430G04031-8G-2	BASE
13	2	McMaster#98381A344 OR EQUIV	STEEL DOWEL PIN 5/16" DIA. x 1-1/4" LG.

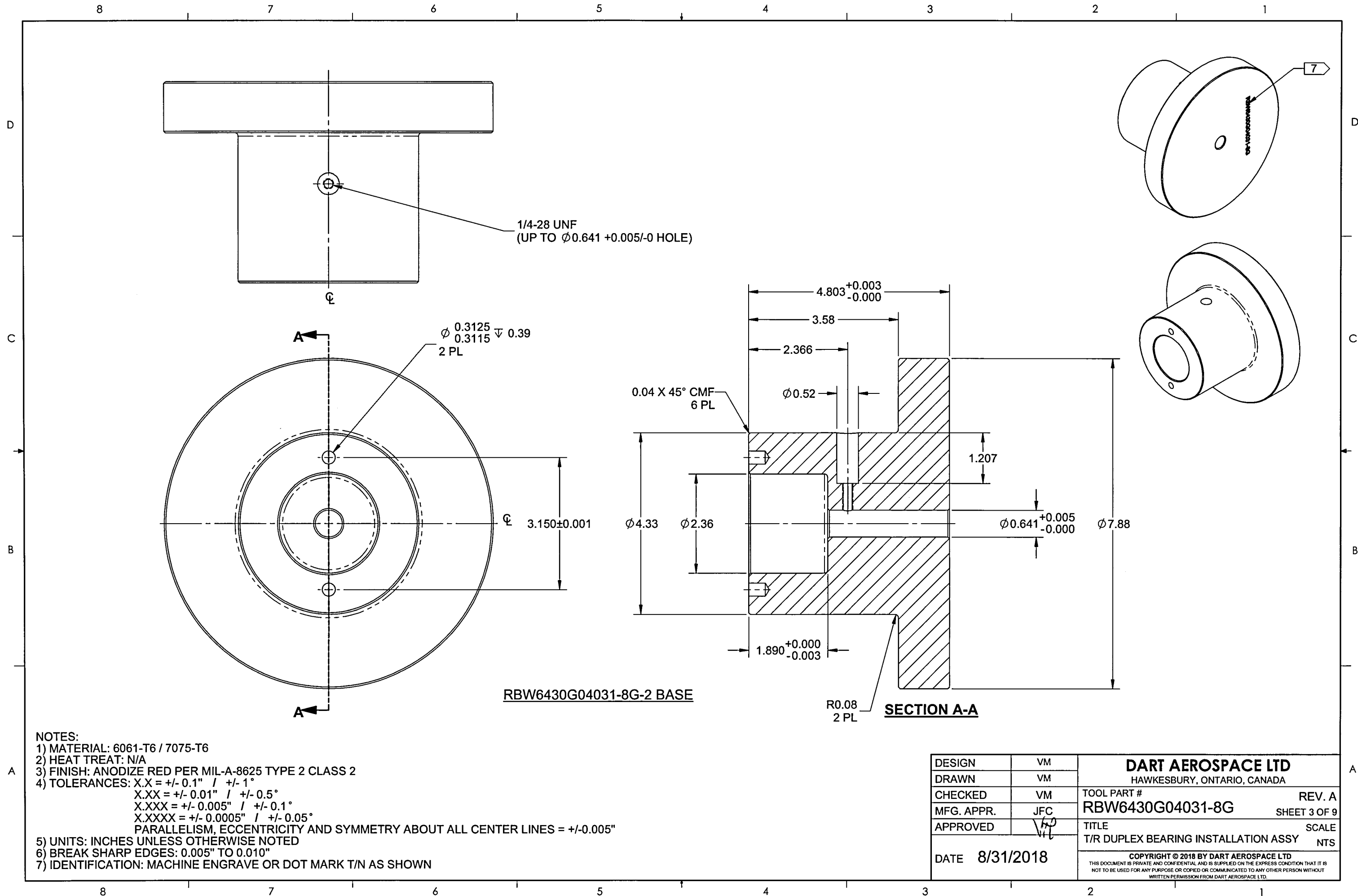


RBW6430G04031-8G-1 BASE ASSY

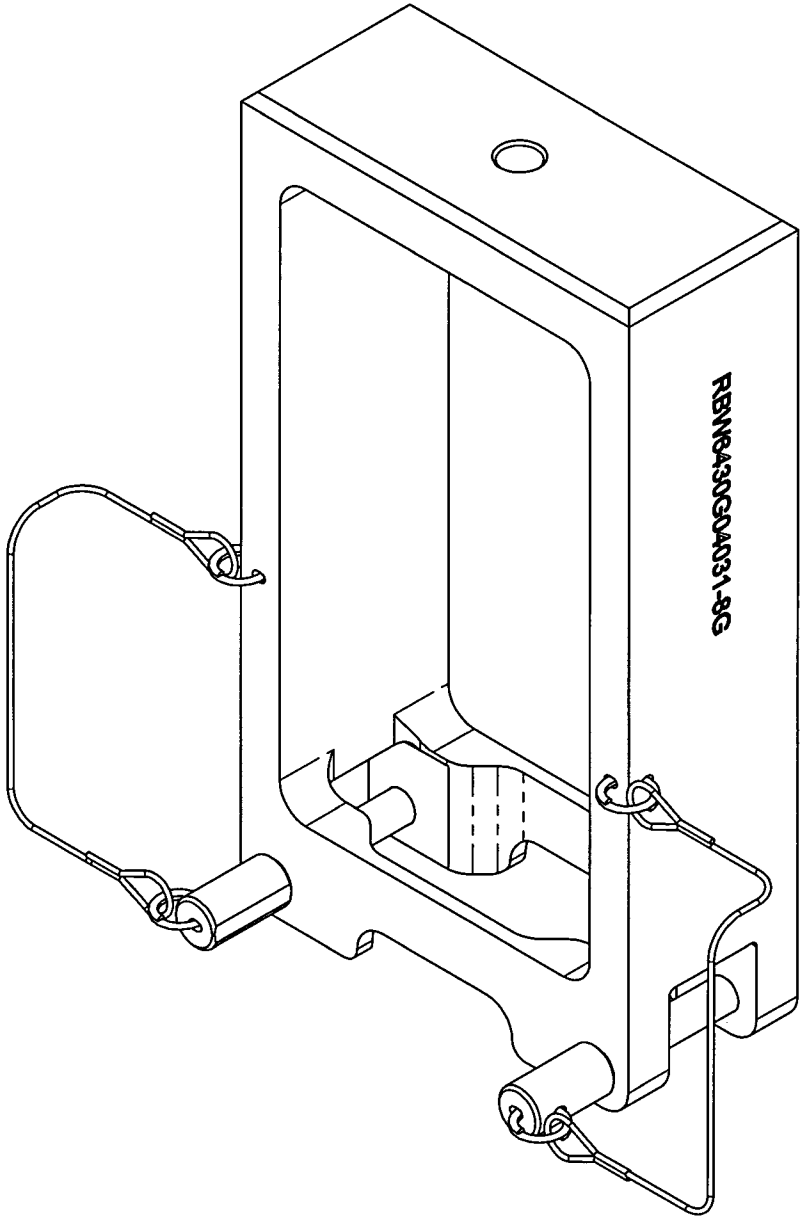


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN,
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 13 WITH ITEM -2 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 2 OF 9
APPROVED	VF	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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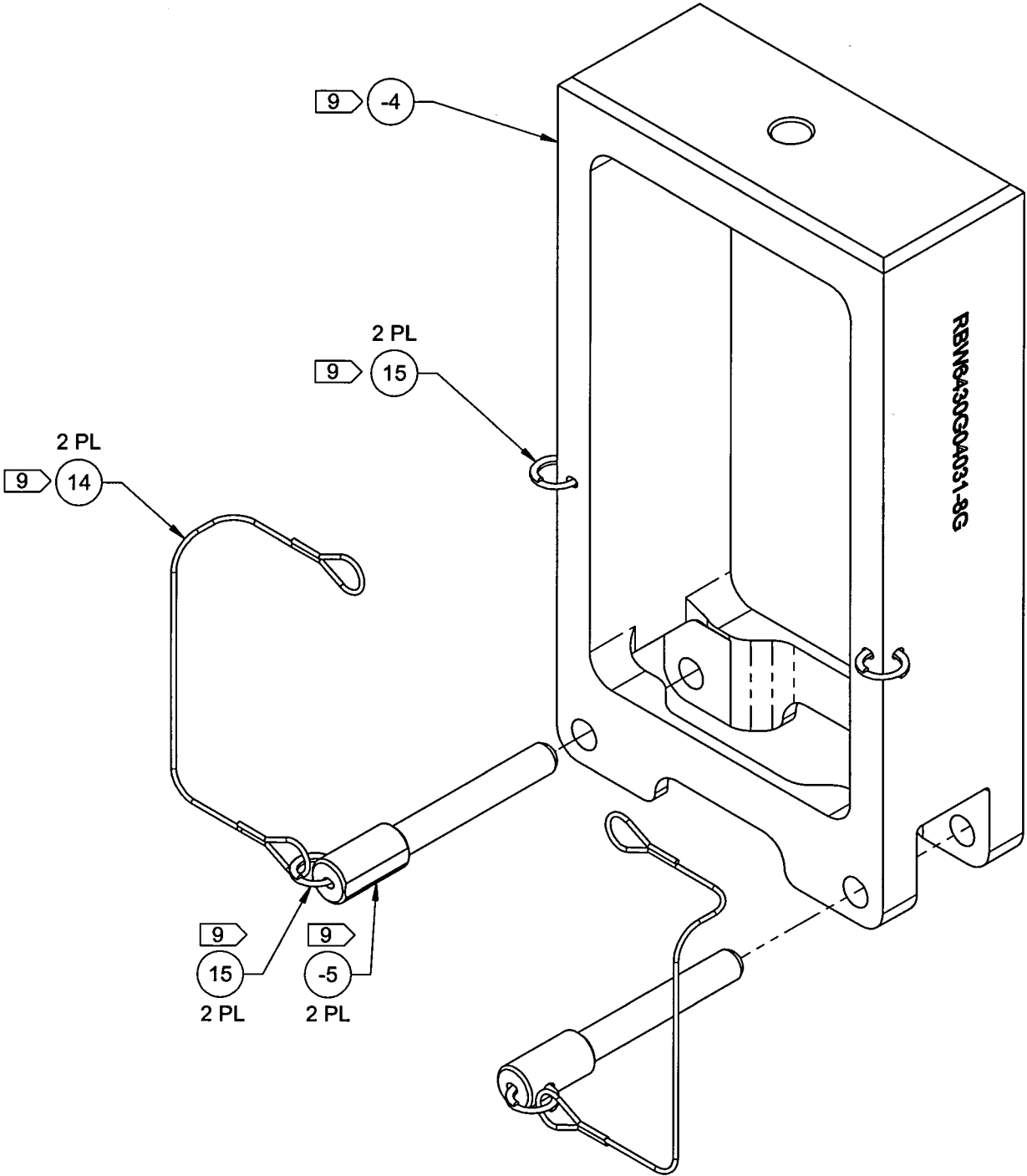


ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6430G04031-8G-4	REACTION
-5	2	RBW6430G04031-8G-5	PIN
14	2	McMaster#90312A271 OR EQUIV	STEEL WIRE ROPE LANYARD 6" LG.
15	4	McMaster#90990A210 OR EQUIV	SS SPLIT RING 11/16" OD x 1/2" ID x 1/8" THK

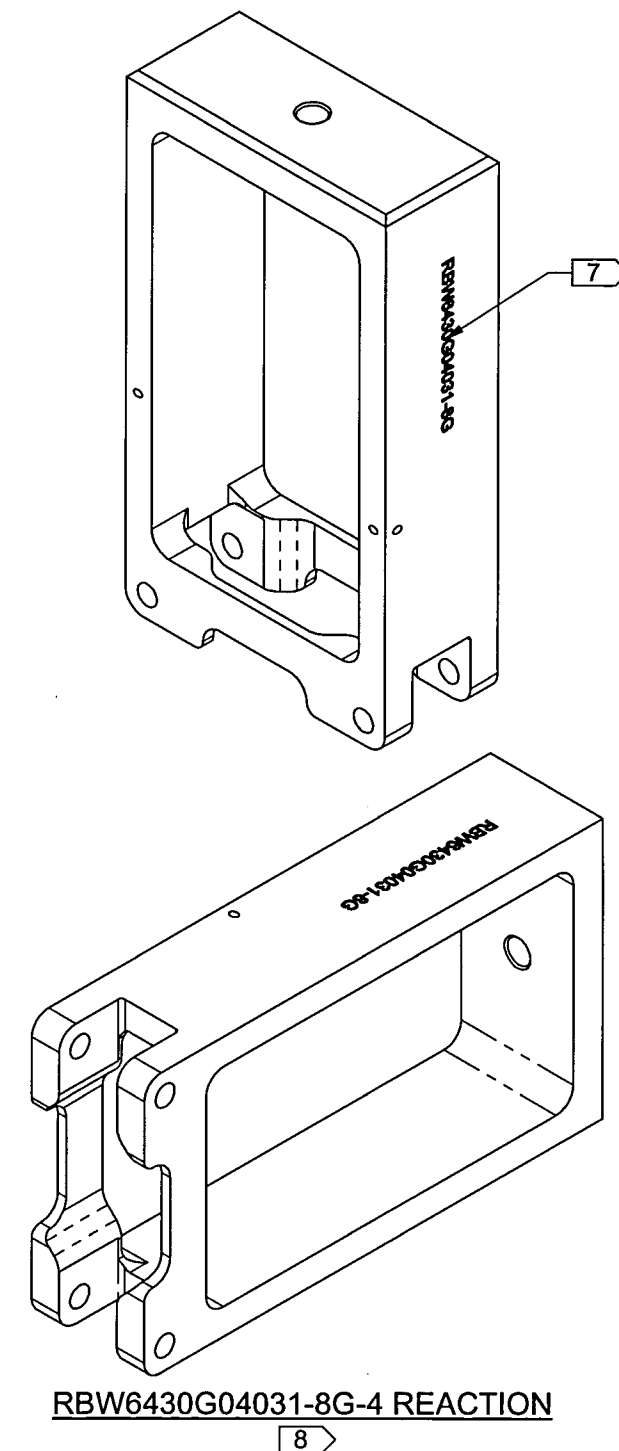
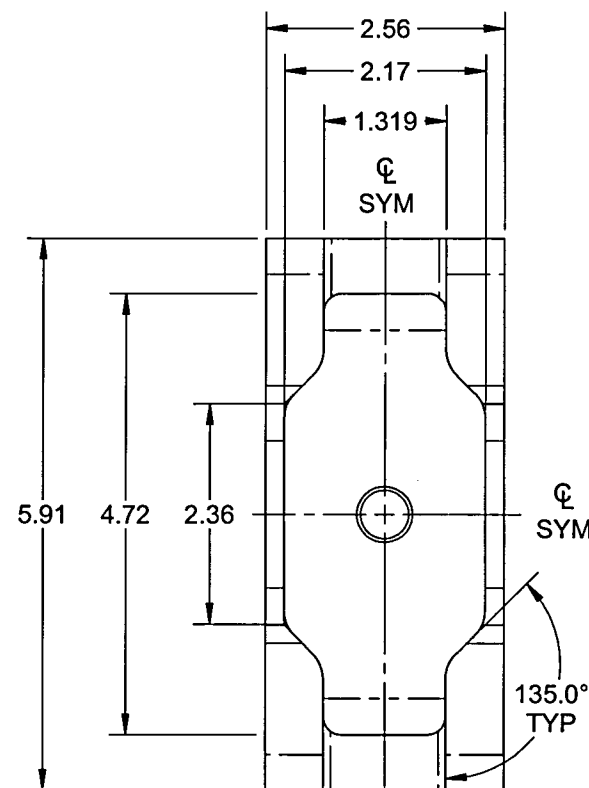
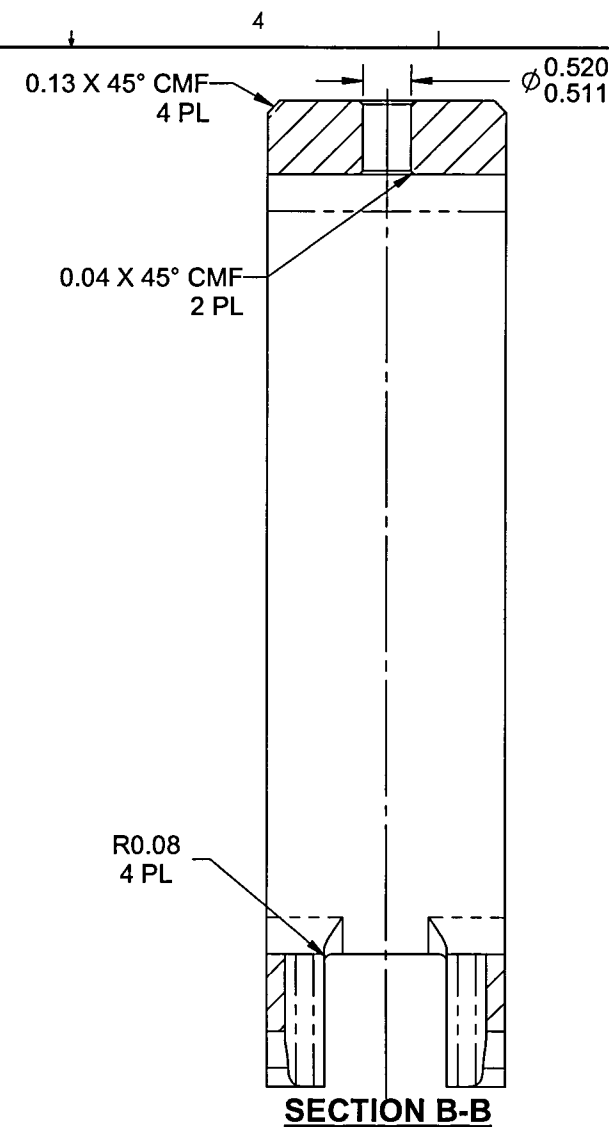
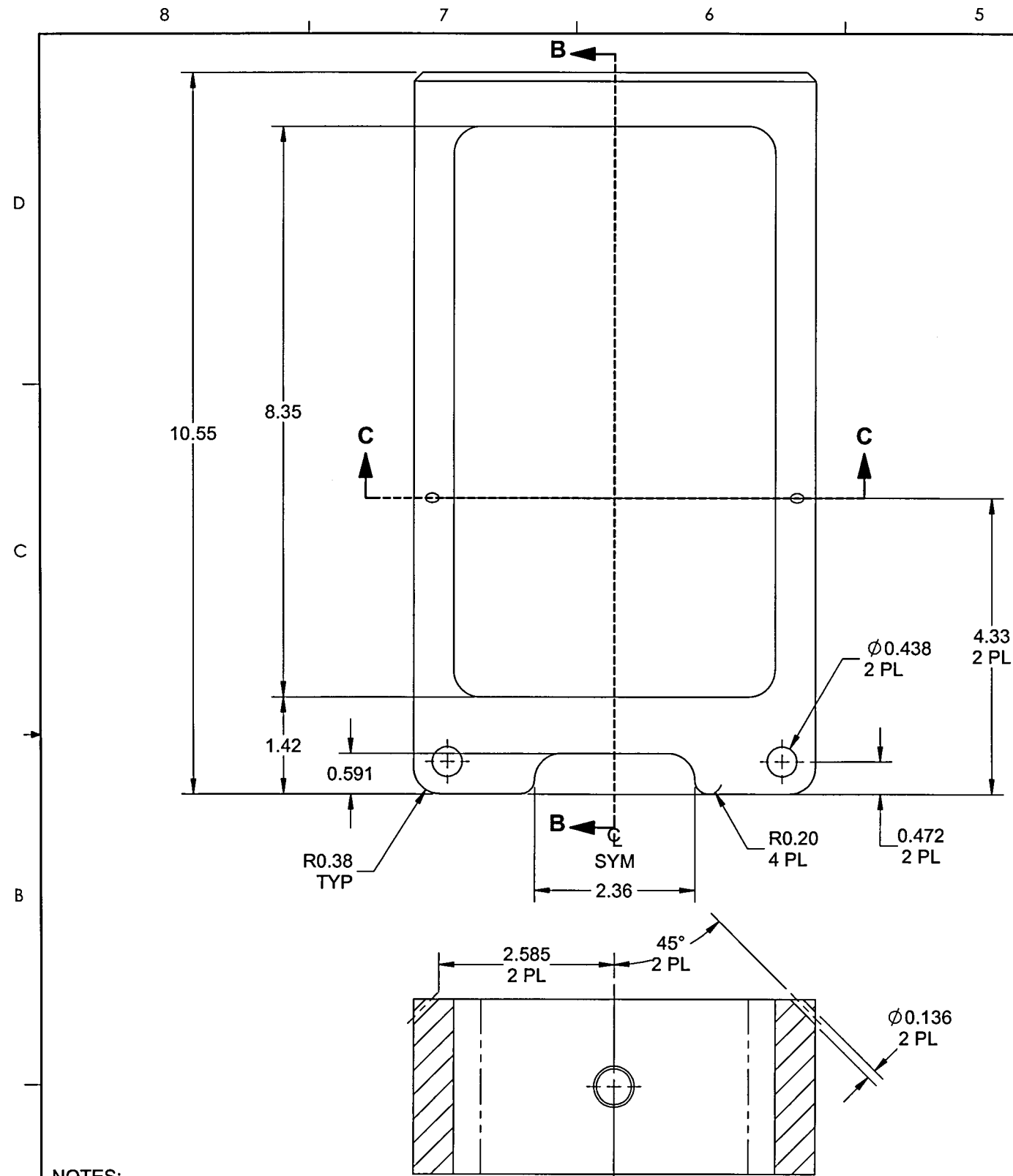


RBW6430G04031-8G-3 REACTION ASSY

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: N/A
 8) ASSEMBLE AS SHOWN
 9) ATTACH LANYARD TO SPLIT RINGS ITEMS 15, ATTACH SPLIT RINGS TO ITEM -4 AND -5 AS SHOWN

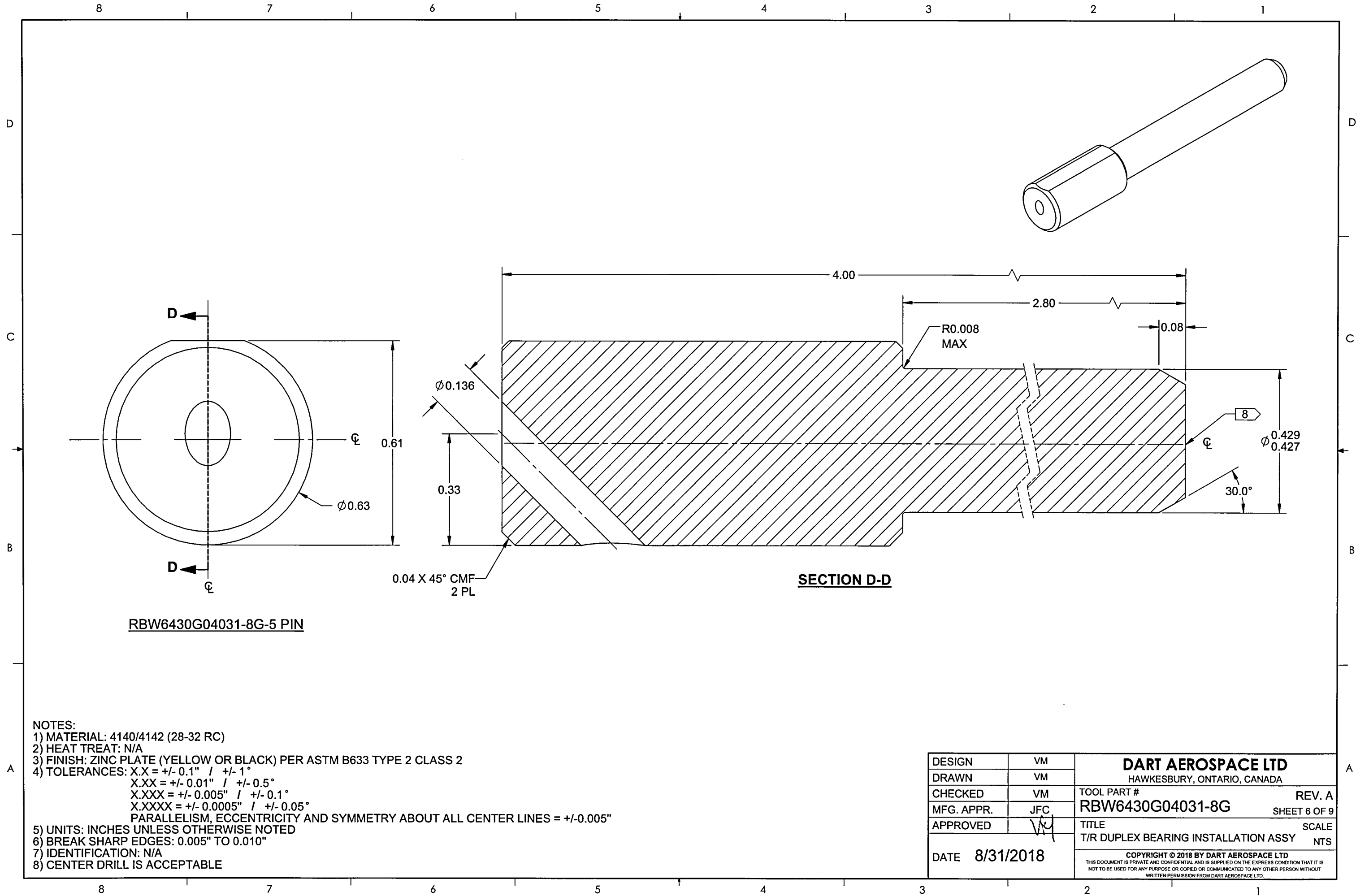


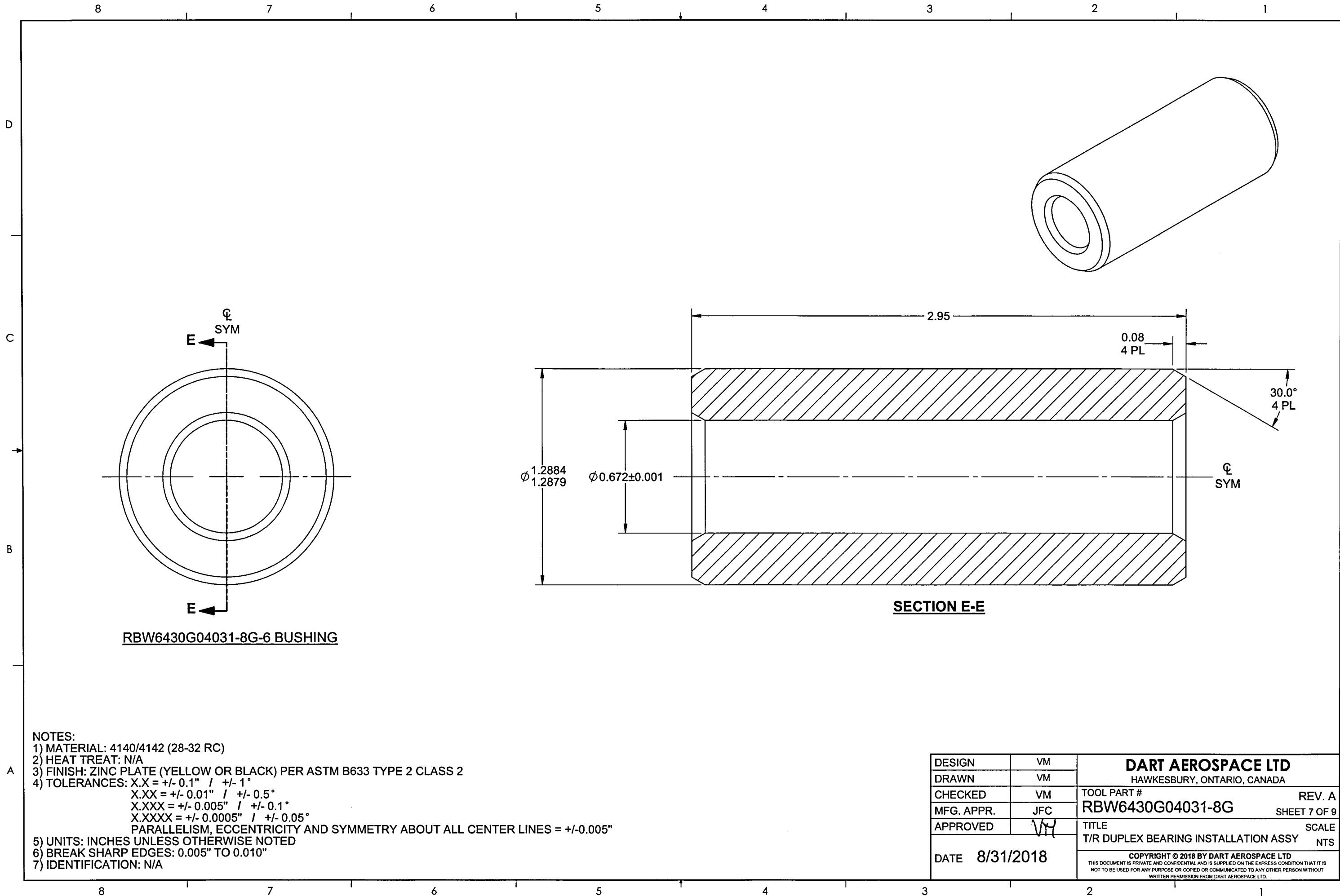
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 4 OF 9
APPROVED	VM	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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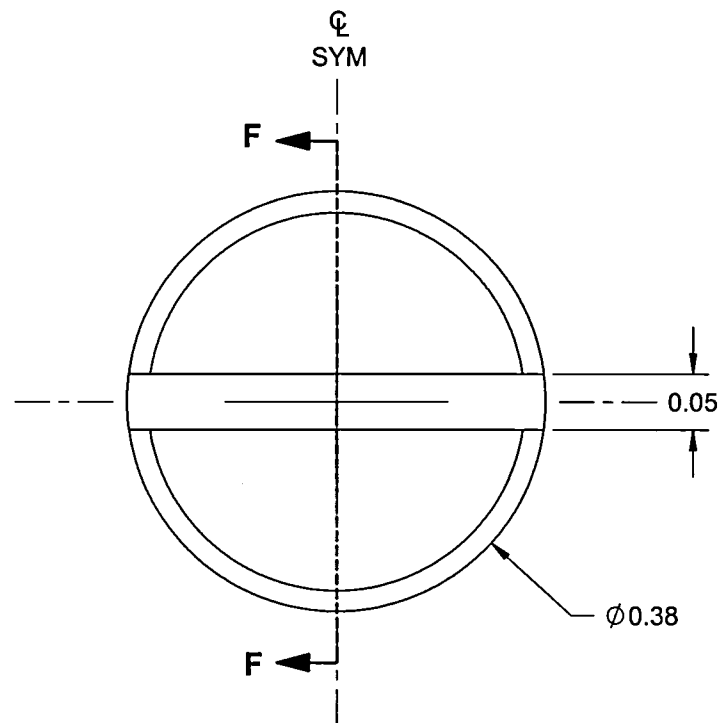


- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF ± 0.005 " PER CAD FILE RBW6430G04031-8G-4.STEP

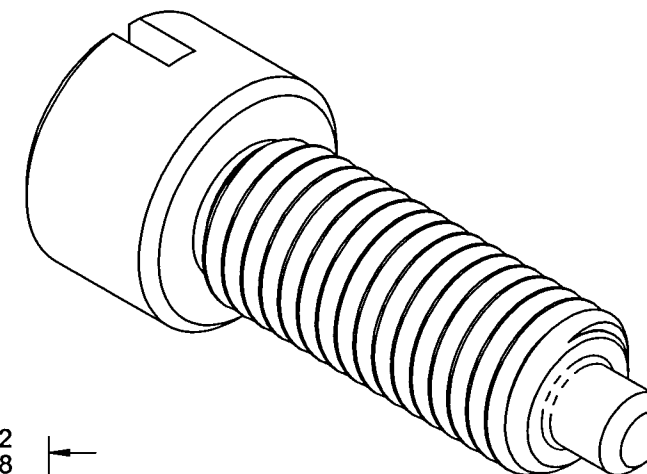
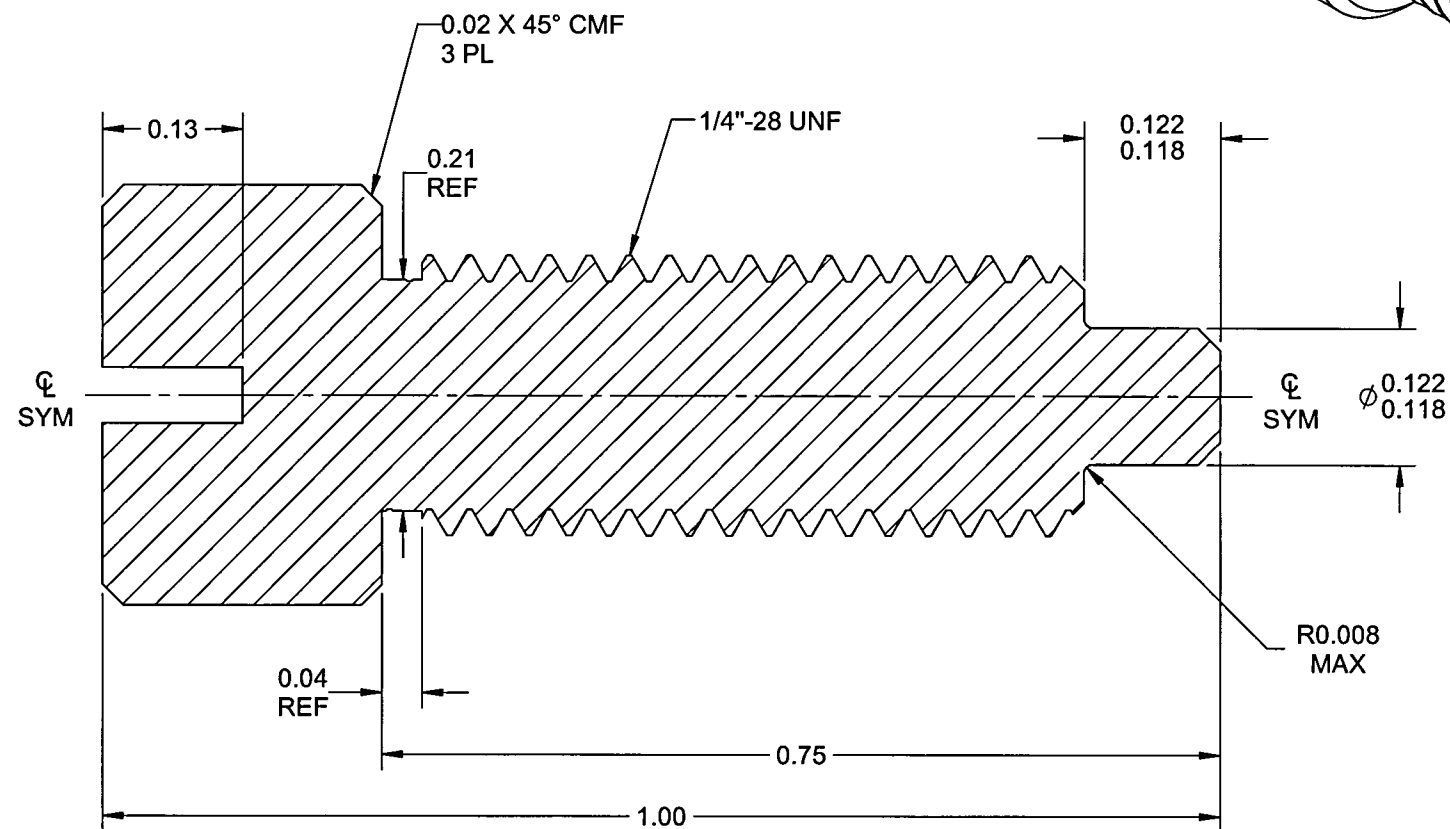
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 5 OF 9
APPROVED	VM	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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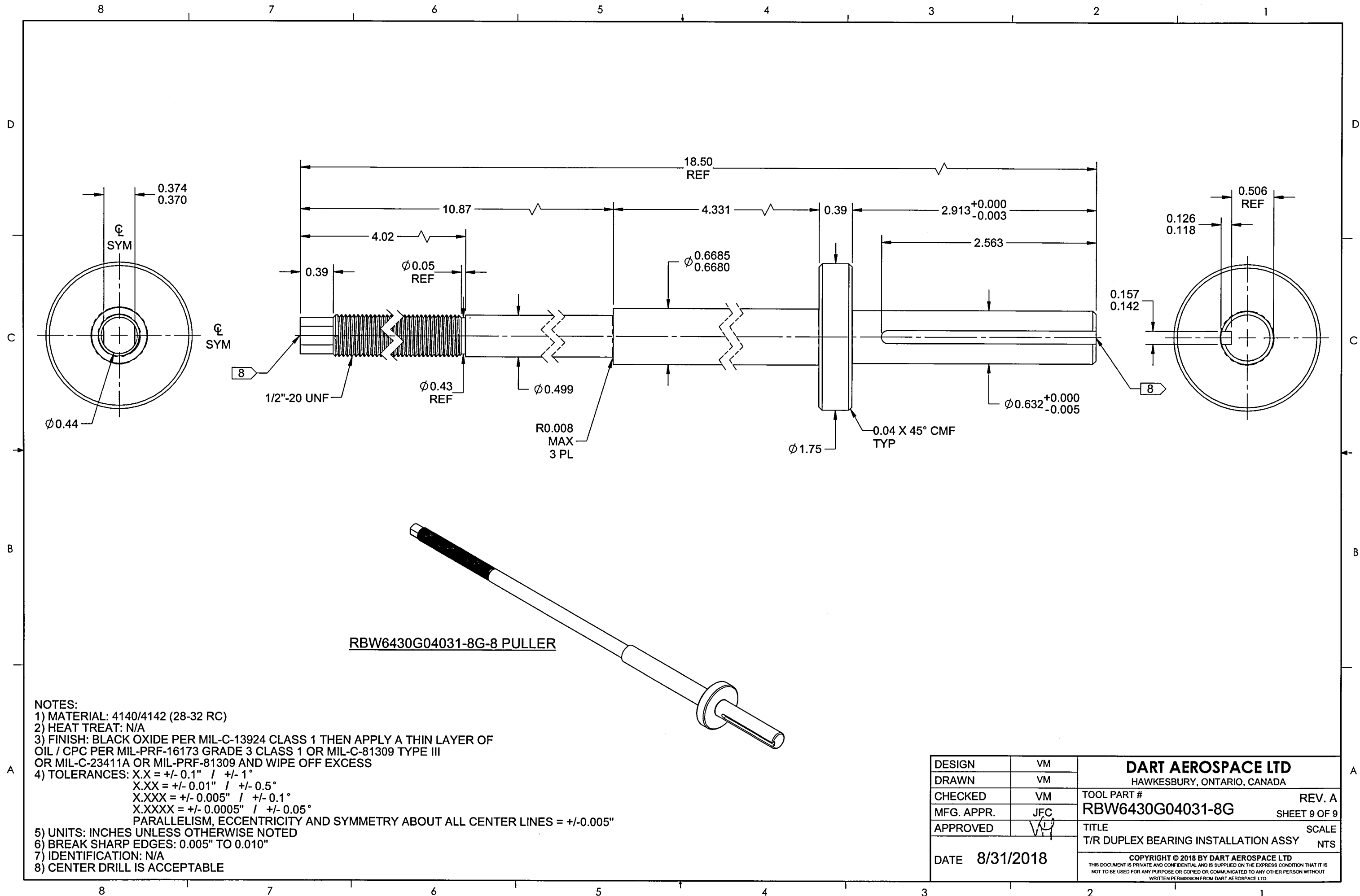


RBW6430G04031-8G-7 SPECIAL SCREW



- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 8 OF 9
APPROVED	VP	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6430G04031-8G	SHEET 9 OF 9
APPROVED	VM	TITLE	SCALE
DATE 8/31/2018		T/R DUPLEX BEARING INSTALLATION ASSY	NTS
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